

Date: Thursday, 6/21/2007 2:30:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33076		
Estimate Number	: 12337		
P.O. Number	: N/A	Part Number	: D3492043
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D3492 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 32997	Material	: N/A
Written By	: <u>JLM</u>	Due Date	: 7/3/2007
Checked & Approved By	: <u>JLM 07.06.22</u>	Qty:	80 Um: Each
Comment	: Est Rev: A 06.03.21 New Issue JLM Est Rev: B 06-08-28 As per Rev B JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 5.2500 f(s)  
 6061-T6 Round Bar .750"  
 (M6061T6R750)  
 Batch: 11102 857

20 07/28/11 + 12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492  
 Dwg Rev: B  
 Folio Rev: B

20 07/28/11 + 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/28/11 + 12

(92)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07.08.13

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

JLM 07.08.13 (92)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:30:02 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33076

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(92X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/15

7.0

POWDER COATING

POWDER COATING



(92)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

BL/FZ

07-08-21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(92X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/08/21

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)

Qty Part Number Description

Batch

1 NAS1611-013 O-RING

M/03500

FZ

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M/01223

FZ 07/08/27

(92)

11.0

QC5

INSPECT WORK TO CURRENT STEP



M/070906

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(92X)

Comment: PACKAGING RESOURCE #1

F-P16

M-L

07/09/06

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(92)

Comment: FINAL INSPECTION/W/O RELEASE

D07/09/06

Job Completion



U 20906

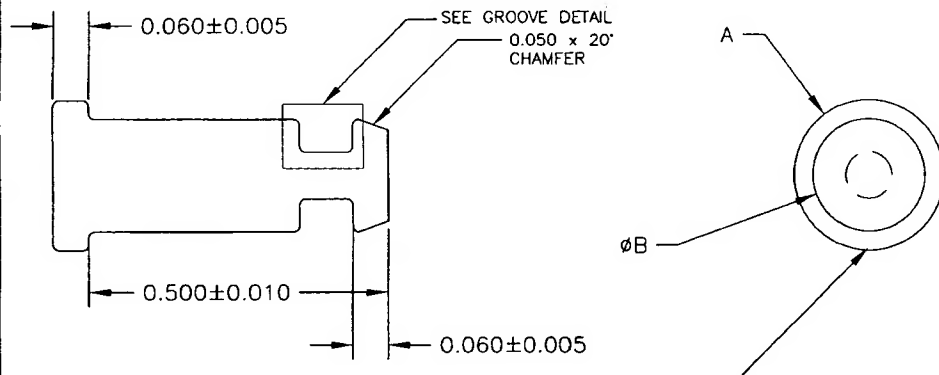
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

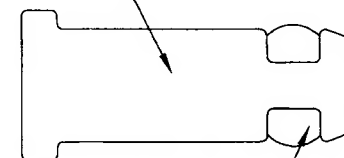
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**

**RELEASED**  
06.10.04 PH  
P/R EUN #361

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

**TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

**D3492-1/-3/-5/-7 PLUG NOTES**

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

NO  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT

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B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.05.11	TITLE
		PLUG
		DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3492
		REV. B
		SHEET 1 OF 1
		SCALE
		NTS

DART AEROSPACE LTD		Work Order:	32997
Description: Plug		Part Number:	D3492-3
Inspection Dwg: D3492	Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/08/11	Date:	07/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue P/O D3492-043	KJ/JLM	
B	06.10.16	Ø0.750 was Ø0.625	KJ/JLM	